

Work Order ID 57355

April 6, 2010 8:56:05 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 06/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date: 10-11-06 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****								
	1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274. <i>H 10/14/17</i>								
	2- remove fwd indexing ridge as per dwg D3274. Prepare for welding <i>H 10/14/14</i>								
	3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: <i>M112507/M113207</i> <i>BE 10/04/14</i>								
	4- grind fwd cap weld on top surface only <i>BE 10/04/14</i>								
	5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.								
	6-Drill Aft cap pilot hole using DT8025								
	7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 <i>M 10/14/14</i>								
	8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #								
	9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.								

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 - - AWM
P-4-14

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 4/10/15

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/15

④

W/O:			WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> 12429 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 10/3/17 <input type="checkbox"/> Start: <input type="checkbox"/> 12/4/15 <input type="checkbox"/> Time: <input type="checkbox"/> 11:10 <input type="checkbox"/> Finish: <input type="checkbox"/> 10/6/17 <input type="checkbox"/> Time: <input type="checkbox"/> 7:50 AM <input type="checkbox"/> (Adhere for 12 hours)								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control:	Memo	0.00							

11/10/4/15

8/10/10/20

80

W/O:			WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

DP 10-4-20

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

BE 10-04-20

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

h2 3.2"

L2 4.6"

10/04/20

10

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ M112507 BE 10/04/29

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 10/05/04

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BE 10/05/05



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Required Date: 16/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00

8 10/05/05



QC

Memo

0.00

Quality Control

FD

220

Pressure Wash per QSI005 4.3

0.00

RE-ALIGNED PAR-09-043.



HandFinish

Memo

0.00

Hand Finishing

① R10-5-6.

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M174207



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:15 AM

⇒ 10/05/06

1 6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
250	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/>								
	2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M 112424</u> Sikaflex expire date: <input type="checkbox"/> <u>10/08</u>								
260	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								

①

BR

10-5-10

①

BR 10-5-12

④

8/10/5/12

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinish

HAND FINISHING RESOURCE #1

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ *M112429*

Sikaflex expire date: ☐ *10/08*

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: _____

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ *M112429*

Sikaflex expire date: ☐ *10/08*

①

BR 10-5-12.

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scoluto

②

W/O:			WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PP 57368 0.00

Packaging

10/08/14 @

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17 HJ
BS10-5-17
①

W/O:			WORK ORDER CHANGES					
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Picklist Print

April 6, 2010 8:56:09 AM

Page 1

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Work Order ID: 57355



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2600-1-190

Manufactured No

110

Each

50.0000

1.0000



Extrusion Round 3" 206



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

47575

50

1

10/14/17

D3285-1

Manufactured No

110

Each

164.0000

1.0000



Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

164

47635

15

52511

74

52647

75

1

BE 10/04/14

D3282-041

Manufactured No

150

Each

4.0000

1.0000



Float Web (206L/407)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

4

52696

4

1

11/14/15

W/O:			WORK ORDER CHANGES					
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Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

85.0000 ¹² 1.0000

Cross Bolt Spacer

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

LG

55000

85

85

D3275-1

Manufactured No

190 Each

20.0000 12.0000



Crossbolt Spacer

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

LG

53453

20

20

CR3212-4-03

Purchased No

250 Each

219.0000 2.0000



Cherry Rivet

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST311

111359 ✓

112314

219

92

127

12 BE 10/04/29

358179 (xG) } BE 10/05/03

2 BR 10-5-12

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date

Picklist Print
April 6, 2010
Work Order

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Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No 250 Each 75.0000 1.0000



Nut Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST056 75

33842 ✓ 75

CCR264SS3-3 Purchased No 250 Each 726.0000 2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST311 726

111548 4

112314 4

113539 92

113973 ✓ 626

ALS4-1032-130 Purchased No 250 Each 40.0000 78.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST282 114407 40

110511 40

1 BR 10-5-12.

2 BR 10-5-12.

78. BR 10-5-12

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Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No 270 Each 19.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 19
 51600 ✓ 7
 56055 12

1 BR 10-5-12

D3536-23 Manufactured No 270 Each 7.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57529 7
 53468 7

1 BR 10-5-12

D3536-35 Manufactured No 270 Each 11.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57530 11
 51628 11

1 BR 10-5-12

W/O:			WORK ORDER CHANGES				
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Appr Chief Eng Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Shop Packet Print

April 6, 2010 8:56:09 AM

Page 5

Work Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-39

Manufactured No

270

Each

11.0000

1.0000



Gasket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

11

48161

1

51637

10

D3535-15

Manufactured No

270

Each

14.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

14

53462

4

56053

10

D3535-35

Manufactured No

270

Each

9.0000

1.0000



Wearshoe



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

9

51608

9

April 6, 2010 8:56:09 AM

Shop Packet Print

Page 5

W/O:			WORK ORDER CHANGES				
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Appro Chief Eng Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8:56:09 AM

Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3535-39

Manufactured No

270

Each

9.0000

1.0000



Wearshoe

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

9

51619 ✓

9

D3535-23

Manufactured No

270

Each

14.0000

1.0000



Wearshoe

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

14

53467

2

56054 ✓

12

D3537-3

Manufactured No

270

Each

20.0000

1.0000



Wearpad

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

20

35697

20

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print
April 6, 2010 8:00 AM

8:09 AM

Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

270

Each

51.0000

9.0000



Wearpad

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

57511

51

55465

51

Purchased No

270

Each

0.0000

80.0000

AN960C10L



washer

AN960C416



washer

NAS1149C0332R

114341

Purchased No

270

Each

377.0000

1.0000

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST346

100993 ✓

377

377

9 BR 10-5-12

80 BR 10-5-12

1 BR 10-5-12

W/O:		WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8:56:09 AM

Work Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270 Each

1,589.000 2.0000



Phenolic Washer

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST077

1589

47628

89

51674

500

52505

1000

AN3C4A

Purchased No

270 Each

1,249.000 80.0000



BOLT

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST350

1249

113226

248

114103

501

114108

500

W/O:			WORK ORDER CHANGES			
DATE	STEP		PROCEDURE CHANGE	By	Date	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April 6, 2010 8:56:09 AM

Work Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

534.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346

534

110552

34

112243

500

1 BL 10-5-12

D2646

Manufactured

No

270

Each

35.0000

1.0000



Aft Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

28

52663

28

Main Warehouse

fp7

7

52663

7

1 BL 10-5-12

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Appro. Chief Eng. Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:56:09 AM

Page 10

Work Order ID: 57355

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
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 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 06/04/2010

Required Date: 16/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

31.0000

1.0000



Ring



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST473

51586

53446

31

8

23

1 BR 10-5-12.

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	QC

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 57355

BS 10-4-06

GENERAL NOTES:

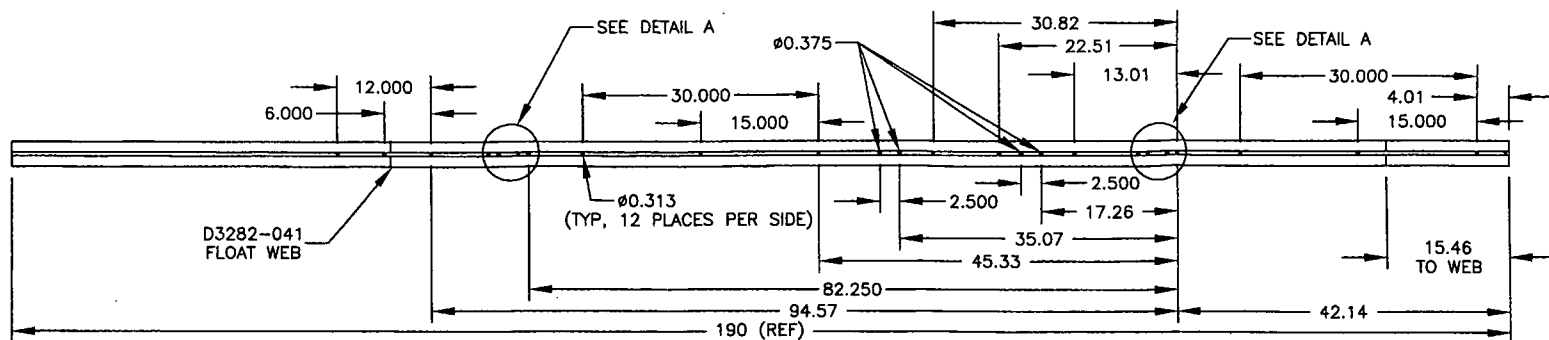
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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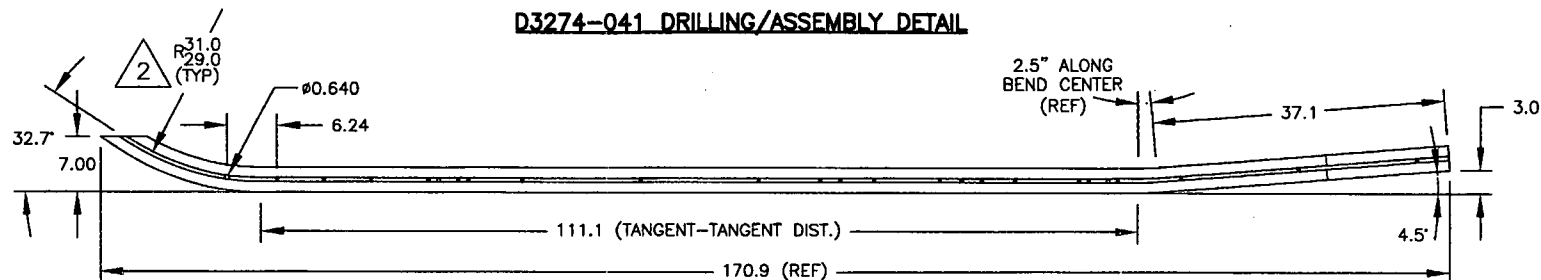
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DEO ATTACHED

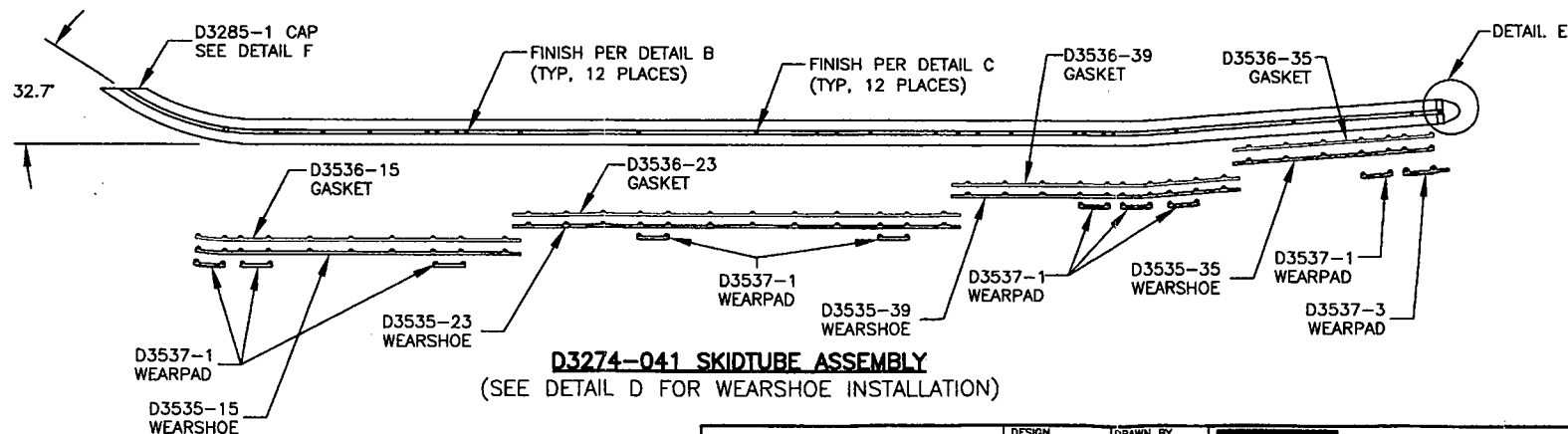
w/o 57355



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

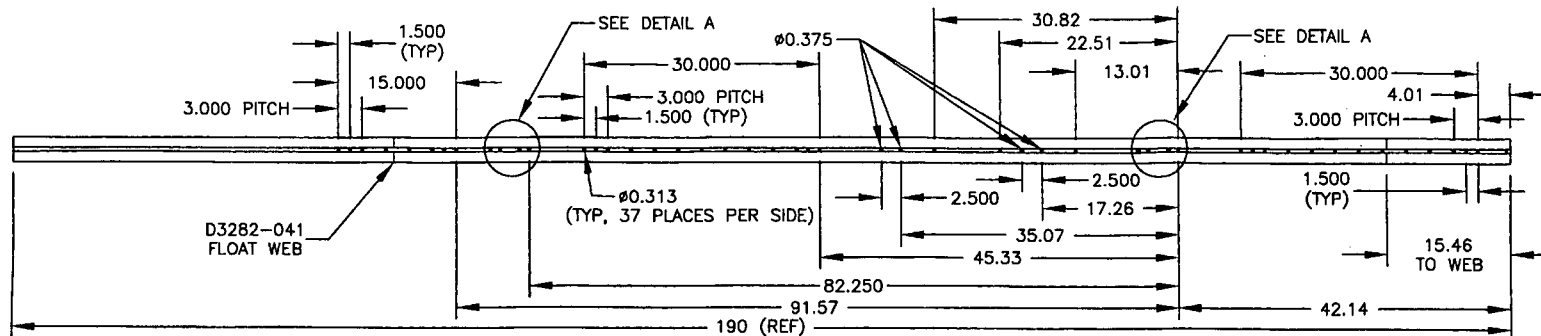
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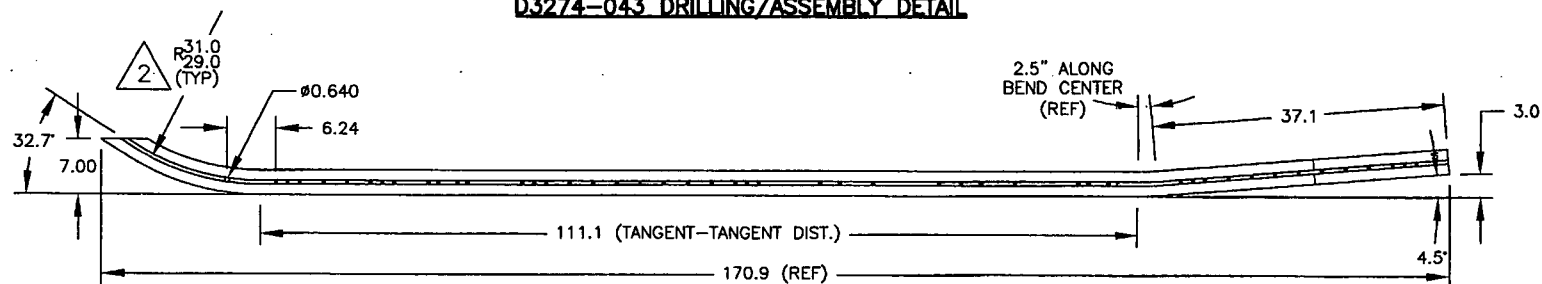
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CHECKED	+	APPROVED	+	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

DEO ATTACHED

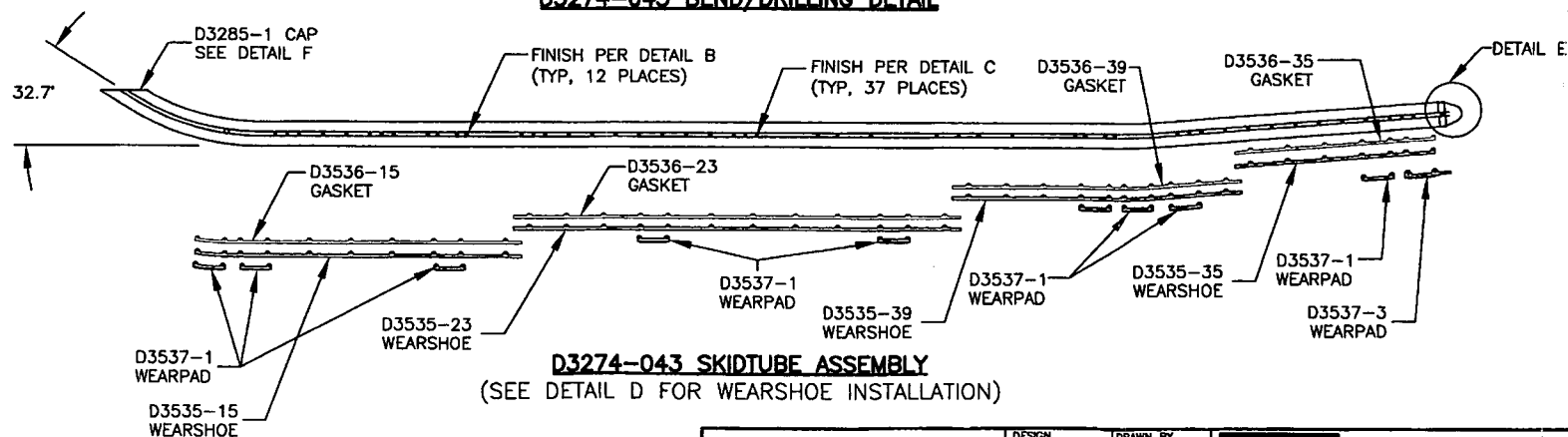
w/o 57355



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

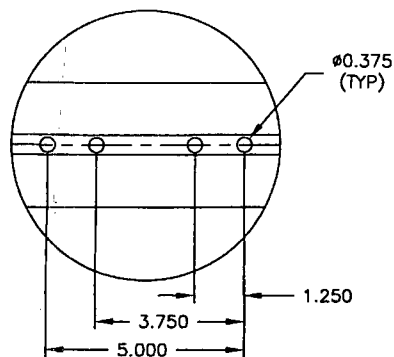
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07.02.12

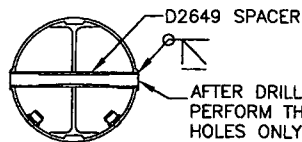
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W/O 57355-

DETAIL A: DRILL DETAIL

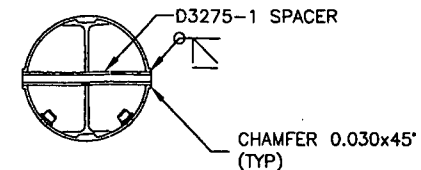


DETAIL B FOR 0.375 HOLES ONLY

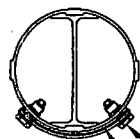


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



DETAIL D

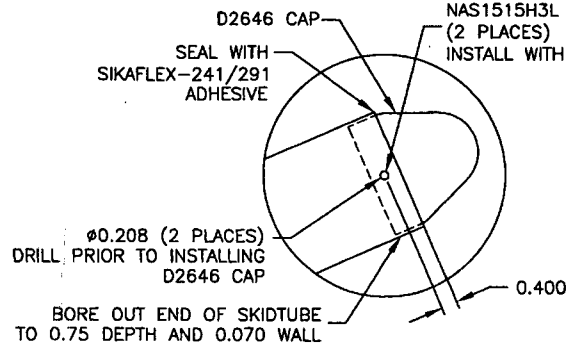


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

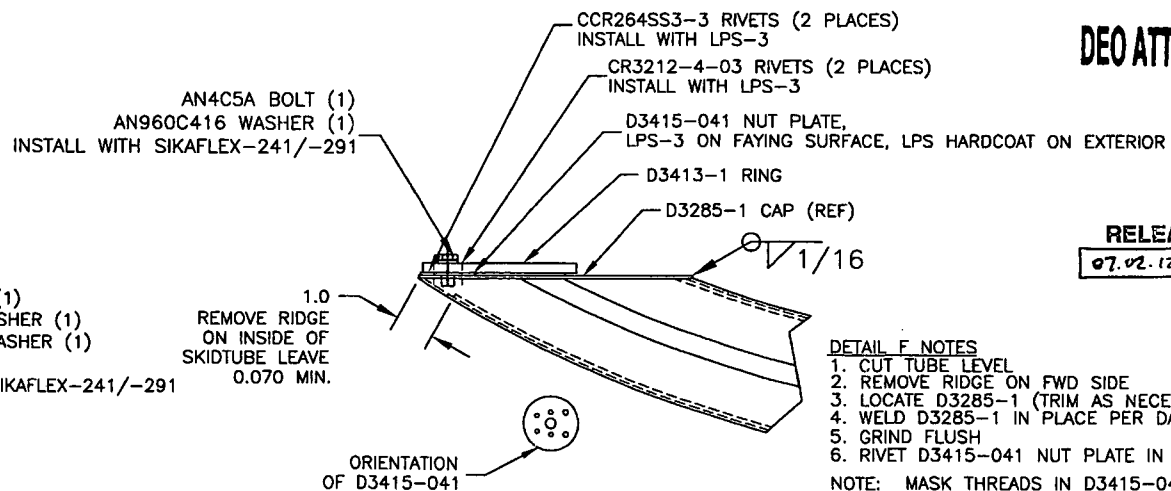
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED

07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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CHECKED	CP	APPROVED	PH	DRAWING NO.	REV. 0
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY		
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TITLE SKIDTUBE ASSEMBLY		REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DATE 09.06.17	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 09.06.23	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

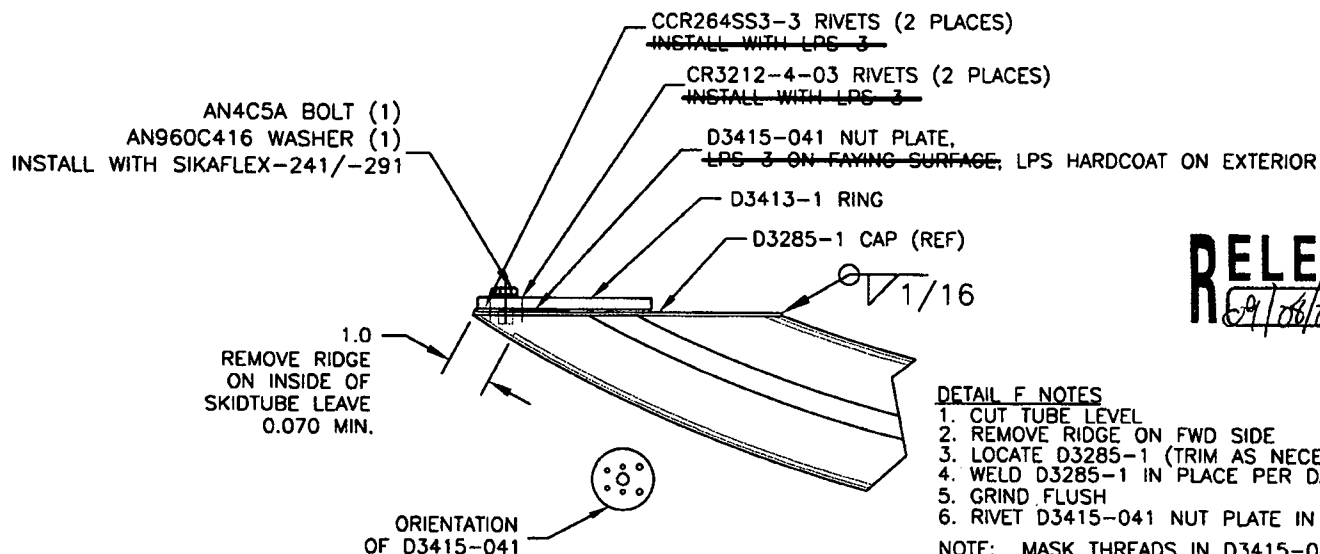
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

wlo 57355

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DRAWING NO.
D3274

NO 230

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 57356
Part number: D206-642-541
Description: flange tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Lat. Phil Date of Test Coupon 10.05.05

Welder Barclay Elliott Date of Test Coupon 10-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld